

Historic, Archive Document

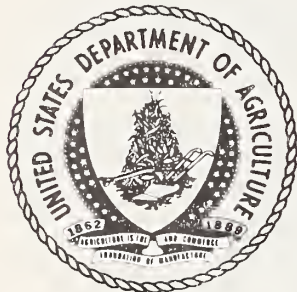
Do not assume content reflects current scientific knowledge, policies, or practices.

ISSUANCES

ATS 1975
Aiu54

of the Meat and Poultry Inspection Program

November 1976



A
P
H
I
S

CONTENTS

MPI Bulletin
76-178, Weekly Code Numbers
for MP Form 404

Changes
76-11, Meat and Poultry
Inspection Manual

76-11, Meat and Poultry
Inspection Regulations

UNITED STATES DEPARTMENT OF AGRICULTURE
Animal and Plant Health Inspection Service
Meat and Poultry Inspection Program
Washington, D.C. 20250

MEAT AND POULTRY INSPECTION (MPI)
PUBLICATIONS

Issuances of the Meat and Poultry Inspection Program. This publication is published monthly by the Issuance Coordination Staff and includes selected CFR amendments, MPI bulletins, and MPI directives; changes to the Meat and Poultry Inspection Manual; and changes to the Meat and Poultry Inspection Regulations. Subscription for 1 year (12 issues) is \$9.00 in U.S. and possessions, and \$11.25 in other countries; cost of one copy is \$0.75.

Meat and Poultry Inspection Manual. This manual contains procedural guidelines and instructions useful in enforcing laws and regulations related to Federal meat and poultry inspection. Copy of the publication and changes since its printing: \$16.50 in U.S. and possessions, and \$20.75 in other countries.

Meat and Poultry Inspection Regulations. This publication contains regulations for slaughter and processing of livestock, poultry, as well as for certain voluntary services and humane slaughter. Copy of the publication and changes since its printing: \$30.00 in U.S. and possessions, and \$37.50 in other countries.

Directory of Meat and Poultry Inspection Program Establishments and Officials. It is published semi-annually. Subscription for 1 year (two issues) is \$7.60 in U.S. and possessions, and \$9.50 in other countries; cost of one copy is \$3.80 in U.S. and possessions, and \$4.75 in other countries.

List of Chemical Compounds. Lists nonfood compounds authorized for use in plants operating under USDA Meat and Poultry, Rabbit and Egg Products Inspection Programs, and the U.S. Department of Commerce, Fishery Products Inspection Program. Cost of one copy is \$2.45 in U.S. and possessions, and \$3.05 in other countries.

U.S. Inspected Meatpacking Plants; A Guide to Construction, Equipment, Layout; Agriculture Handbook No. 191. This handbook is designed to supply interpretation of regulations and guidelines in designing, building, altering, and maintaining meatpacking plants to operate under Federal inspection. Cost of one copy is \$2.90 in U.S. and possessions, and \$3.65 in other countries.

Accepted Meat and Poultry Equipment. This publication is published three times yearly, contains information on equipment construction and acceptance, and lists commercially available equipment acceptable for use in federally inspected meat and poultry plants. Subscription for 1 year (three issues) is \$5.65 in U.S. and possessions, and \$7.10 in other countries; cost of one copy is \$1.90 in U.S. and possessions, and \$2.40 in other countries.

HOW TO ORDER

Persons, other than MPI personnel, should write to the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402. Check or money order should be made payable to the Superintendent of Documents and should accompany the request.

CORRESPONDENCE

Correspondence on subscriptions should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Correspondence on the contents should be addressed to USDA, APHIS, MPI, Issuance Coordination Staff, Washington, D.C. 20250.

Correspondence by MPI personnel on the mailing and distribution should be addressed through the regional director, and by State personnel through the State program director and MPI regional director to USDA, APHIS, Administrative Services Division, Room 727-A, Federal Building, Hyattsville, Maryland 20782.

UNITED STATES DEPARTMENT OF AGRICULTURE
Animal and Plant Health Inspection Service
Meat and Poultry Inspection Program
Washington, DC 20250

MPI BULLETIN 76-178
11/16/76

ACTION BY: Inspectors in Charge, Food Inspectors, and Plant Management.

INFORMATION FOR: Regional Directors and Area and Circuit
Supervisory Personnel.

Weekly Code Numbers for MP Form 404

The following weekly code numbers are for completing MP Form 404, Processing Operations at Official Establishments:

1977

<u>WEEK CODE</u>	<u>WEEK CODE</u>
1/January 2, 1977 - January 8, 1977	18/May 1 - May 7
2/January 9 - January 15	19/May 8 - May 14
3/January 16 - January 22	20/May 15 - May 21
4/January 23 - January 29	21/May 22 - May 28
	22/May 29 - June 4
5/January 30 - February 5	
6/February 6 - February 12	23/June 5 - June 11
7/February 13 - February 19	24/June 12 - June 18
8/February 20 - February 26	25/June 19 - June 25
	26/June 26 - July 2
9/February 27 - March 5	
10/March 6 - March 12	27/July 3 - July 9
11/March 13 - March 19	28/July 10 - July 16
12/March 20 - March 26	29/July 17 - July 23
13/March 27 - April 2	30/July 24 - July 30
14/April 3 - April 9	31/July 31 - August 6
15/April 10 - April 16	32/August 7 - August 13
16/April 17 - April 23	33/August 14 - August 20
17/April 24 - April 30	34/August 21 - August 27
	35/August 28 - September 3

DISTRIBUTION: A-O
P,Q,S,T,U
(Issuances)

CATEGORY: I-Forms

REGS: 320
Subpart Q
MANUAL: 20.13

OPI:
WSDS

WEEK CODE

36/September 4 - September 10
37/September 11 - September 17
38/September 18 - September 24
39/September 25 - October 1

40/October 2 - October 8
41/October 9 - October 15
42/October 16 - October 22
43/October 23 - October 29

WEEK CODE

44/October 30 - November 5
45/November 6 - November 12
46/November 13 - November 19
47/November 20 - November 26
48/November 27 - December 3

49/December 4 - December 10
50/December 11 - December 17
51/December 18 - December 24
52/December 25 - December 31, 1977

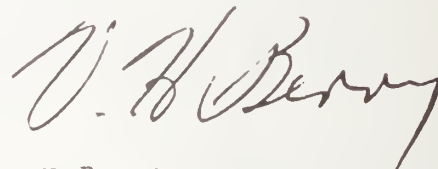
1978

WEEK CODE 1/January 1, 1978 - January 7, 1978

See Section 20.13 and Chart 20.1 of the Meat and Poultry Inspection Manual for completing MP Form 404. Mail original not later than the first Tuesday following the reporting period. Negative reports are required.

The inspector must assure that (1) the establishment actually processed all items reported, (2) no item has been omitted, (3) amounts shown are reasonably correct, and (4) items are reported in the correct column.

This bulletin becomes effective January 2, 1977, and cancels MPI Bulletin 75-157.



V. H. Berry
Acting Deputy Administrator
Meat and Poultry Inspection Program



UNITED STATES DEPARTMENT OF AGRICULTURE
Animal and Plant Health Inspection Service
Meat and Poultry Inspection Program
Washington, D.C. 20250



MEAT AND POULTRY INSPECTION MANUAL

CHANGE: 76-11

Maintenance Instructions

November 1976

Remove Page	Insert Page	Numbered
43 and 44	43 and 44	76-11
79 and 80	79 and 80	76-11
165 thru 168	165 thru 168	76-11
175 and 176	175, 176, and 176a	76-11
235 thru 236b	235 thru 236b	76-11
261 and 262	261 and 262	76-11
291 and 292	291 and 292	76-11

Pen-and-Ink Changes

Page 236e, left column, section 22.26-A (a), line 12, after word "States" add "or Canada."

Page 250, right column, line 4, change the word "fact" to "face."

MPI Bulletins Included

Changes on page 261 cancel MPI Bulletin 76-151.

Changes on pages 236 and 236a cancel MPI Bulletin 76-139.

product contact zone. Data should be reported as microbes per square inch.

4. Develop a microbiological control and monitoring program. Record all information as follows:

a. Microbiological control (preoperative sanitation instructions, sanitary operation specifications, environmental control).

b. Microbiological monitoring (sampling, laboratory procedure, actions).

Written instructions should be directed to involved plant employees.

5. Submit proposed program, with plant's sanitation requirements and procedures, to the inspector in charge, who will send it with his comments to STS-SDS through appropriate supervisory channels.

* 6. Provide copy of the accepted program for the inspector's file.

* (2) Changes. Proposed revisions to update and/or improve the microbiological control and monitoring program should be submitted to STS-SDS as described above.

(h) Midshift Cleanup Requirement

A program approval does not relieve the plant from other required sanitary practices. Plant failure to comply with all provisions of this subpart will require a midshift cleanup.

Approval of a program does not relieve inspection personnel from their responsibilities. The inspector in charge shall:

* 1. Review, evaluate, and recommend approval or disapproval of proposed program and/or revisions.

* 2. Familiarize himself with details of accepted procedures.

* 3. Evaluate sampling procedures.

* 4. Monitor plant adherence to procedures and evaluate its effectiveness and program deviations, including frequent reviews of plant records.

* 5. Assure adequacy of corrective action.

6. Notify the supervisor when plant refuses to adhere to program procedures.

7. Withhold program acceptance and revert to midshift cleaning and sanitizing with circuit supervisor's approval.

ANTE-MORTEM INSPECTION

PROCEDURE

Subpart 9-A

(Regs: M-309; P-Subpart J)

9.1 PURPOSE

Ante-mortem inspection is to accept only animals (livestock or poultry) capable of producing products acceptable for use as human food. Such inspection removes from human food channels animals: (1) obviously unfit for human food because of diseases or abnormalities; (2) with diseases or conditions difficult to detect on routine post-mortem inspection (central nervous system disorders, chemical poisoning); (3) with zoonotic diseases (ornithosis, poultry erysipelas, etc.). It also prevents unnecessary contamination of slaughtering departments, and provides information on suspect animals for post-mortem inspection.

9.2 FACILITIES, EQUIPMENT, LOT

The establishment will provide adequate facilities, equipment, and necessary supplies, and will determine the number of animals (livestock or poultry) comprising a lot. Ante-mortem inspection shall be performed only on lots identified for slaughter by the establishment.

9.3 ASSISTANCE

Plant management shall provide sufficient employees to move, segregate, restrain, identify, and dispose of animals as requested by the inspector.

9.4 INSPECTION DAY

Ante-mortem inspection must be made by an MPI employee--veterinarian, or inspector under veterinary supervision --before daily slaughter operations begin, except for low volume plants (see Section 9.8), and according to regulations and/or instructions issued by the Administrator.

Subsequent Inspections. These shall be made, as necessary. Inspectors assigned to small plants may have to stop post-mortem inspection procedures to perform ante-mortem inspection.

9.5 OBSERVATION

(a) Livestock

Cattle, calves, swine, sheep, goats, horses, or other equines shall be observed when at rest and in motion.

(1) At rest. The inspector shall observe cattle, large calves, horses, or other equines from outside the pen; small calves, swine, sheep, and goats from inside.

(2) In motion. All animals shall be observed on both sides while in motion.

A mirror may be used to view the opposite side of each animal.

Excitement of animals should be avoided.

(b) Poultry

Poultry shall be observed while they are in coops or batteries before or after removal from truck(s).

9.6 SEGREGATION

Animals (livestock or poultry) showing signs of abnormalities or

(d) Record

Each inspector shall have the "trim helper" record on MP Form 514 condemned carcasses in the appropriate blocks and all carcasses retained for veterinary examination under the word "retained" entered in the remarks space.

(1) Plant rejects. Carcasses rejected by management before inspection shall be condemned and recorded on MP Form 514 under "other." The statement "Rejected by Plant Management" shall be entered under remarks.

(2) Unlisted conditions. Carcasses condemned for unlisted abnormalities or diseases shall be recorded on MP Form 513, 514, and 514-1, under "remarks" or "other" with condemnation reason.

(e) Retained Product

When product is retained for further inspection, identity and wholesomeness should be preserved. Identity can be maintained by keeping product under Government lock or seal, and/or by using retained tags. Product wholesomeness can be maintained by preventing contamination, dehydration, and decomposition with plastic bags, slush ice, or other (refrigeration or freezing) means. If necessary, samples of retained product may be sent to the laboratory (see Part 23).

(f) Systemic Condition

When a systemic condition is evident, carcass and viscera must be condemned.

(g) Liver Condemnation

Livers with the following diseases or abnormalities must be condemned:

1. Fatty degeneration--characterized by well defined light spots. Livers with a uniform yellow color, due to excessive fat deposits (fatty infiltration), are considered wholesome. They are commonly found in fat birds, especially fowl, and occasionally in fryers.

2. Extensive petechiae or hemorrhages. The typical "paint brush"

appearance is considered insignificant.

3. Inflammation, abscess, necrosis.

4. Cirrhosis, tumor, cyst. Livers with one large cyst or several small cysts shall be condemned.

5. Discoloration--caused by gall bladder or bile duct disorders, post-mortem changes, etc.

6. Specific disease (entero-hepatitis).

7. Contamination--from intestinal contents or noxious materials.

(h) Kidney Condemnation

Kidneys shall be removed from carcasses showing:

1. Renal or splenic pathology.

2. Hepatic lesions causing liver condemnation.

3. Conditions requiring condemnations of all viscera.

4. Airsacculitis--when carcass or its posterior part is salvaged.

(i) Contamination

Carcass and/or part disposition shall be according to regulations (P-381.91). Fecal, ingesta, or bile contamination must be promptly removed by washing and/or trimming. Contamination of carcass cut surfaces and internal parts must be removed by trimming.

Inspectors shall assure themselves that contamination is properly removed.

(1) Salvage operation. Contaminated product may be salvaged, provided (1) adequate facilities and personnel are available, and (2) procedures, approved by area supervisor, are always done sanitarily.

(i) Facilities.

1. Salvage station. It should be in the eviscerating area and have adequate space for a sanitary and effective operation.

2. Retain rack. Each station shall have adequate retain racks in

rows and high enough to prevent cross contamination of suspended carcasses.

3. Trough or table. A trough or table section with a steep, sloping top, drained into a gutter or other drainage facility, is necessary. A stainless steel grill for dropped hand tools is desirable over the table or trough.

4. Singer.

5. Containers. Vats, tanks, or other suitable containers for chilling product. Knife rack or stand.

6. Spray nozzle with proper fittings to clean carcasses.

7. Gooseneck or other acceptable facility for washing hands and tools.

8. A minimum of 50-foot candles of light.

(ii) Procedure.

1. After viscera removal, the trimmer may hang contaminated carcasses (by the neck) on designated area of retained rack. Number of carcasses hung depends upon facilities, production rate, and employee's capability.

2. Carcasses are then transferred from retain rack to salvage station, where they are suspended with anterior end up to prevent contamination during washing and trimming.

3. External carcass surfaces will be thoroughly washed before cutting.

4. Salvage must be done (a) by properly trimming contaminated tissues, (b) without cutting into body cavity and opening cut edges, and (c) without product pileup or other insanitary procedure.

5. Salvaged parts must be chilled immediately (with crushed ice in continuously drained containers).

(iii) Inspector's responsibility.

The inspector in charge must assure that all requirements are met and only wholesome product is saved for food purpose. Plant failure to comply with the provisions of this section will require discontinuing salvage operations.

(2) Overscald. It should not be confused with hard scald. In over-scald the skin slips from the meat, and the intestine may appear cooked.

Carcasses or parts partially cooked by singer or other causes shall be condemned and recorded as overscald.

(j) Bruises; Tears

Trimming bruises, hemorrhages, or tears requires judgment based upon extent, nature, and practicability of trimming to meet ready-to-cook requirements. The following guides apply to ready-to-cook product only, and not to grading standards: *

1. Entire carcass shall be condemned when a bruise or hemorrhage is associated with systemic disturbance.

2. When a condition is localized, the carcass may be passed for food after removal and condemnation of affected part(s).

3. Areas, showing blood clumps or clots in superficial tissues--between skin layers or superficial muscles (wing vein rupture), loose subcutaneous tissue, along blood vessels, etc.--may be slit and the clots completely washed out before the part is passed for food. When blood clumps extend into the muscles, affected part(s) shall be removed and condemned. *

4. Areas with slight reddening shall be handled according to section 381.89 of the regulations. *

(1) Breast blister. Although inflammatory tissue adheres tightly to keel bone, affected tissues must be removed.

Removal of breast blisters or other abnormalities before inspection is not permitted since it may affect carcass disposition.

Carcass chilling is not allowed before blister removal, except when carcasses are retained several hours for reinspection, or when blister-affected carcasses belong to lots of

Any lot found contaminated with foreign material shall be retained. The establishment shall determine and correct the deficiency before resuming normal operations.

When above-listed operations qualify for minimal or limited inspection, the inspector shall monitor such operations when he visits the plant.

(c) Animal Fat

Submit samples of animal fat for species determination when product mislabeling is suspected--tallow in lard or vice versa (see Part 23).

(d) Vegetable Oil

Submit samples of incoming shipment of vegetable oils for possible presence of animal fats. Sample as instructed by regional or area office. Submit a 1-pound sample of mono- and/or diglycerides when used in products.

(e) Noncompliance

A lot in which a sample is found contaminated or otherwise not in compliance shall be retained. Product shall be cleaned, recycled, or disposed of as acceptable to the circuit supervisor.

18.55 SPECIAL PRODUCTS (Meat)

(a) Partially Defatted Tissue

Partially defatted beef or pork fatty tissue and partially defatted chopped beef or pork, manufactured by low temperature rendering processes, require use of acceptable raw materials, prompt chilling, and subsequent freezing of the residue.

To insure production of sound and properly labeled products, the following safeguards must be observed:

(1) Raw materials. They must be from official plants and recent production lot, in excellent condition, and stored at room temperature of 50° F. or less. Kill floor fats

moved within the plant directly to rendering units are exempt from this temperature requirement.

(2) Meat used. A representative sample of meat trimmings to be used must contain at least 12 percent lean meat, as determined by knife-cutting separation, for product labeled "partially defatted chopped beef" or "partially defatted chopped pork." Since lean meat percent can be determined at plant level, samples should not be sent to the laboratory.

Compliance with this requirement is determined by the plant drawing a 5-pound sample unit from each of 10 different containers of raw material. The inspector designates containers to be sampled by a random selection procedure. The test shall be performed under his supervision. Tests shall be made at least twice during each shift. Each 5-pound sample unit must average at least 12 percent lean meat for the product to be classified as partially defatted chopped beef or pork. Leaner cuts of meat may not be added to lots of raw material which fail these requirements to bring such lots into compliance.

(3) Chilling. Partially defatted product shall leave the refrigeration cycle of the process at 40° F. or less.

(4) Freezing. The partially defatted product shall be rapidly frozen to 30° F. within a 6-hour period unless immediately used in product.

(5) Laboratory samples. Frequent samples shall be sent to the Microbiology Laboratory to evaluate plant's inspection controls. Samples must be frozen and adequately packed to prevent defrosting in transit.

(b) Oleomargarine

MPI maintains inspection over plants manufacturing oleomargarine with animal fats for interstate commerce. Such inspection deals with sanitation of the plant, wholesomeness of all raw materials, and accuracy of labeling. FDA is responsible for inspection of oleomargarine prepared without animal fats. However, MPI will require correction of insanitary conditions in parts of official plants used for making vegetable margarine.

MPI personnel are required to cooperate with FDA to assure adequate sanitation coverage is maintained over plants manufacturing oleomargarine with and without animal fats.

* **(c) Skins For Popping**

* Pork skins will be checked for hair roots before or after popping. Popped product must be free from hair roots.

* **(1) Definitions**

* **(i) Sample block.** Twenty-five square inches of skin; one or more pieces of skin may make up a sample block. Check only 10 sample units in each sample block.

* **(ii) Sample unit.** One square inch of skin in a sample block.

(iii) Sample size. Number of sample blocks required according to the lot weight (fresh). *

(iv) Sampling overlay. Transparent plastic sheet containing a 5"x5" area lined into 25 one-inch squares. Ten squares are clear and 15 are shaded. See example in Figure 18.4. The 10 clear squares identify the sample units to be checked. Several sampling overlays with varied shaded out 1-inch squares should be available for inspector's use. *

(v) Defective unit. A sample unit with one or more hair roots. *

(vi) Acceptance number (Ac). The maximum number of defective units in the sample that will permit the acceptance of the lot. *

(vii) Rejection number (Re). Minimum number of defective units in a sampling plan requiring lot rejection. *

(2) Sampling; inspection procedure. The inspector shall: *

a. Determine the lot size (using fresh weight) and identify the required sample size (number of sample blocks) from Table 18.13. *

Table 18.13 Pork Skin Sampling

Lot Size (Pounds)	Sample size (blocks)	Sample units	Sampling Plans			
			Normal		Tightened	
			Ac	Re	Ac	Re
3,000 - under	6	60	10	11	7	8
3,001 - 12,000	12	120	17	18	12	13
12,001 - 18,000	20	200	27	28	19	20
18,001 - over	32	320	41	42	28	29

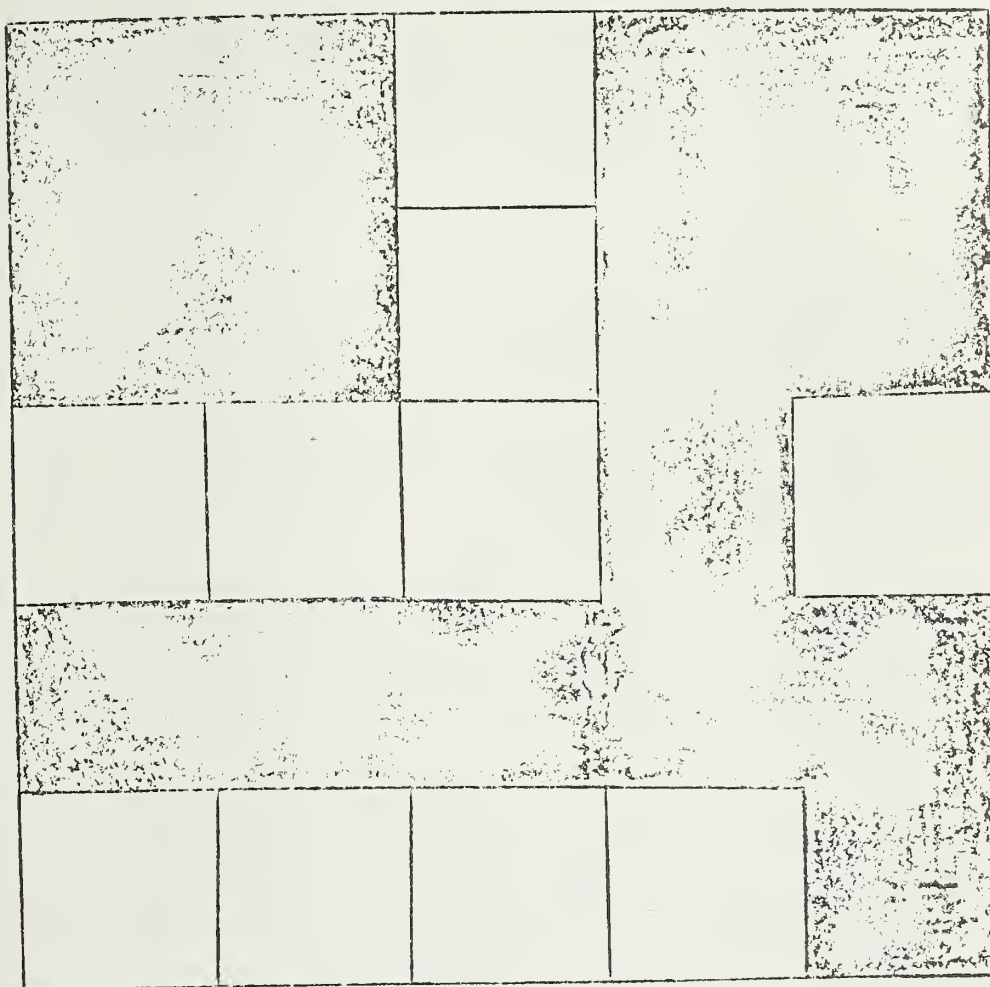


Figure 18.4 - Sampling Overlay

* b. For each lot, randomly select one
 * carton of fresh skins for each required
 * sample block, or, randomly select
 * enough popped skins (prior to packag-
 * ing) throughout the lot for each
 * required sample block.

* c. Randomly select and use one sam-
 * pling overlay for each lot. Determine
 * and record number of defective units
 * identified in the 10 clear 1 inch
 * squares of all sample blocks in the lot.

* If skins are frozen, remove frost
 * from sample blocks before checking.

* d. Total the number of defective
 * units; compare the total number with
 * the Ac - Re criteria in Table 18.13;
 * accept or reject the lot accordingly.

(3) Reinspection. A rejected lot
 may be reinspected after recondition-
 ing using the tightened criteria.

*
 *
 *

DEHYDRATION (POULTRY)

Subpart 18-J

Dried poultry products may be placed in cans. To prevent oxidation of remaining fat, oxygen is replaced with nitrogen or other inert gas.

18.58 METHODS; MATERIALS

Dehydration may be accomplished by (1) drum drying on heated rollers, (2) spray drying, (3) low temperature vacuum, or (4) heat drying in ovens. Poultry meat may also be dehydrated by heating in edible oil at 212° F.; however, product will contain some oil.

(a) Oven Heating

Cooked poultry meat is ground and spread in thin layers on pans or trays. A vacuum applied during oven drying permits water removal at lower temperatures.

(b) Freeze Drying

Frozen pieces of meat are submitted to heat under high vacuum. The meat's ice-formed water evaporates directly from solid to vapor state without product thawing. Product does not shrink as in other dehydrating systems.

(c) Drum-Spray Drying

This method is similar to milk drying. A slurry may be dried by spraying directly into heated air.

(d) Antioxidants

In poultry meat slurries, some fat is normally present. Therefore, sufficient antioxidant may be added during dehydration to produce a product with acceptable keeping quality. The inspector must assure that only approved antioxidants are used, and that their total weight does not exceed 0.02 percent of the fat (weight) present in the product to be dehydrated. Fat content must be accurately determined to properly control antioxidant concentration in finished product.

NET WEIGHT

Subpart 18-K

(Regs: M-317; P-Subpart N)

Net weights must be accurate. Systematic plant controls must be maintained over container contents to comply with regulations.

18.61 NET WEIGHT

(a) Definition

Net weight includes all nutritious contents suitable for food. It is the gross weight minus the tare weight.

When meat or poultry product is packed in nonnutritious medium--water, brine, agar--the net weight is the drained weight.

(b) Determination

Net weight may be determined by approved quality control system or lot inspection.

(1) Approved quality control.

(i) Inspector. When a plant quality control system, approved by STS-SDS is in effect (Subpart 18-A), the inspector shall:

1. Assure that approved procedure is on file in the Government office. Such procedure includes sampling rates, limits, and actions to be taken when limits are exceeded.

2. Observe plant sampling, weighing, and recording of random intervals at least five times a week.

VIGNETTE, DECLARED COUNT

Subpart 18-L

(Regs: M-317; P-Subpart N)

frozen dinners), sampling may be done with routine plant surveillance. Sample size and acceptance criteria are as indicated above. Sampling rate may exceed above rate.

18.63 PRODUCT APPEARANCE AND COMPOSITION

When a label vignette shows several slices or one or more exposed surfaces (e.g., canned hams, turkey rolls, dinners, pies, etc.), the product shall be of comparable appearance and composition.

(a) Definitions

(1) Lot. A shift's production of an item with a specific label showing certain quality characteristics.

(2) Deviant. Sample unit (product from one container) without a slice or exposed surface of comparable quality or appearance with the vignette.

(b) Lot Sampling

Sample 10 percent of the lots, but not more than five lots a week. Randomly select five containers from each (sampled) lot and inspect product by halving or slicing if necessary. When samples are found acceptable for 4 consecutive weeks, sampling will be reduced to one lot a week. If a lot is found in violation, the inspector will return to initial rate.

A lot is acceptable if deviants are not in the five-sample units. The lot is in violation if two or more of the five-sample units are deviants. If one of the five-sample units is a deviant, examine five more randomly selected containers, and accept the lot if none of these is a deviant. Reject the lot if one or more additional sample units are deviants.

When the inspector can verify compliance with label vignette without destructive sampling (e.g., certain

18.64 DECLARED COUNT

When a label shows count of product units (meat or poultry) in the container, either by actual count, range, minimum count, or by group of units, lot compliance shall be confirmed.

(a) Actual Count

When actual count is declared (e.g., "10 meatballs," "approximately 8 drumsticks," etc.):

1. Randomly select samples according to Table 18.20 and determine minimum and maximum limits for any sample container according to Table 18.21. For example, the label states 11 units. This count falls into the 10-15 range so the minimum acceptable count is the declared count, 11 units, and the maximum acceptable count is 13 (the declared count plus 2 units). A deviant is any container with less than 11 or more than 13 units, unless excess units are proportional (as defined in the next paragraph) to stated net weight or required meat weight. Each container in the sample may contain 13 units.

2. Determine compliance by comparing number of sample containers exceeding limits in Table 18.21 with number permitted in Table 18.20. In this example, if 13 samples were taken, the lot would fail if any container had less than 11 units or more than two containers had over 13 units, unless the excess units were proportional.

Counts should be proportional to stated net weight or required meat weight. The extra units must increase the meat weight or net weight by at least 90 percent of the weight of the extra units times the average weight of a unit. For example, "four meatballs" are declared on a label. The container requires a minimum of 2 ounces of meatballs. Maximum count

* allowable from Table 18.21 is five.
 * If six meatballs were found and they
 * weighed 2.9 ounces or more, the con-
 * tainer would not be considered a
 * deviant. If the weight of the meat-
 * balls was less than 2.9 ounces, it
 * would be considered a deviant. The
 * calculation for determining compli-
 * ance in the above examples is:
 * a. Four meatballs are required to
 * weigh 2 ounces so each meatball is
 * approximately 0.5 ounces.
 * b. The container contained six meat-
 * balls or two more than the declared
 * count.
 * c. The increase in the meat weight
 * must be at least 90 percent of the
 * extra units so: 2 ounces (required
 * meat) + .90 x 2 (the number of extra
 * meatballs) x 0.5 ounces (the average
 * weight of a meatball) = 2.9 ounces.
 * If seven meatballs had been found,
 * they would have to weigh at least 3.35
 * ounces for the container to be accept-
 * able.

* (b) Exact Count

* When vignette shows an exact number
 * of units, follow the procedure
 * described under "actual count."

* (c) Minimum Count

* When a minimum count is declared on
 * the label, a deviant is any count less
 * than the count on the label or if the
 * average weight of the extra units in
 * excess of the minimum count in the con-
 * tainer are not proportional. For
 * example, a minimum count of 10 units
 * and a net weight of 5 ounces is
 * declared on the label. The plant
 * targets at 12 units in order to meet
 * the minimum count. Table 18.21 shows
 * the declared count plus two is accept-
 * able. If 13 units are found in a con-
 * tainer, the same procedure as in "a"
 * above applies. That is, 5 ounces + .90
 * x 3 x .5 ounces = 6.35 ounces which is
 * the minimum required net weight to be
 * considered acceptable.

(d) Range

* When declared count on label is given*
 * as a range (65 to 70 drumsticks): *

1. Select samples according to *

Table 18.20. *
 2. The minimum and maximum counts *
 are the extremes of the declared range. *
 Any container with less than the min- *
 imum or more than the maximum count is *
 a deviant unless maximum count is pro- *
 portional. *

3. Accept or reject according to *
 criteria in Table 18.20. *

(e) Group of Units

* When the label shows a group of *
 units, (1) select samples according to *
 Table 18.20, (2) count the units easily *
 identified in the vignette, (3) count *
 the units in each sample, and (4) cal- *
 culate the average count per container. *
 A deviant is any container with a *
 count less those easily identifiable *
 on the vignette (this count may also *
 fail the meat ingredient or net weight *
 requirement), or the weight not being *
 proportional. For example, meatballs *
 in sauce, the vignette has four easily *
 identifiable meatballs, and the net *
 weight is 10 ounces. This requires *
 the container to have 5 ounces of meat- *
 balls. Six cans are opened and the *
 average of the six is 10 meatballs so *
 the average weight of each meatball is *
 0.5 ounces. A deviant is a can with *
 less than four meatballs (check if *
 meat ingredient requirement is met) or *
 a can with more than 12 meatballs, *
 unless they are proportional as defined *
 in "a" above. If the average of six *
 containers was nine meatballs, then *
 each meatball would be 5 ounces ÷ 9 *
 meatballs = 5/9 or .56 ounces. In this *
 case, a deviant is still a can with *
 three meatballs, or any can that con- *
 tains more than 10 meatballs with no *
 proportional increase in the weight of *
 the meatballs. *

Table 18.20 - Declared count; lot size

Lot size (containers)		Sample size	Acceptable no. of containers	
			Below minimum limits (AQL 2.5)	Above maximum limits (AQL 6.5)
50 ounces or less	over 50 ounces			
2,400 or less	1,200 or less	3	0	.0
2,401 - 12,000	1,201 - 7,200	6	0	1
12,001 - 24,000	7,201 - 15,000	13	0	2
24,001 - 48,000	15,001 - 24,000	21	1	3
48,001 - 72,000	24,001 - 36,000	29	2	4
72,001 - 108,000	36,001 - 60,000	38	2	5
108,001 - 168,000	60,001 - 84,000	48	3	6
168,001 - 240,000	84,001 - 120,000	60	3	7
Over 240,000	Over 120,000	72	4	8

Table 18.21 - Range of declared count

Declared or illustrated count	Single count	
	Acceptable count in container	
	Minimum <u>1</u> /	Maximum <u>1</u> /
2-9	Declared count	Declared count plus 1
10-15	Declared count	Declared count plus 2
16-21	Declared count	Declared count plus 3
22-27	Declared count minus 1	Declared count plus 3
28-33	Declared count minus 2	Declared count plus 3
34-40	Declared count minus 2	Declared count plus 4
41-47	Declared count minus 3	Declared count plus 4
48-53	Declared count minus 3	Declared count plus 5
54-60	Declared count minus 4	Declared count plus 5
61-67	Declared count minus 4	Declared count plus 6
68-74	Declared count minus 5	Declared count plus 6
75-80	Declared count minus 5	Declared count plus 7
Over 80	Declared count minus 6	Declared count plus 7

1/ Each container in the sample may contain this number of units.

identification and control system must be established for identity of the beef/mutton/lamb ingredient through formulation, processing, labeling, storage, and packing for shipment. MP Form 412-3 covering exports prepared as described above must bear the added statement "The (beef) (lamb) (mutton), byproducts, or meat food products thereof covered by this certificate originated in a country, recognized by Canada, where the use of diethylstilbestrol is prohibited as a growth promotant."

(iv) Beef from Canadian cattle.

Beef, beef products, and beef byproducts, if from Canadian cattle directly transported to federally inspected plants in the U.S. for immediate slaughter, may be exported without DES certification. VS maintains a list of plants approved for slaughter of such cattle (VS Memorandum 591.15). Adequate identity of animals and their products must be maintained. Products to be exported need only be accompanied by MP Form 412-3, signed by an MPI veterinarian, showing the following statement on the reverse: "The meat products identified on this certificate were derived from cattle of Canadian origin transported for immediate slaughter. The identity of the products as derived from Canadian origin cattle has been maintained through slaughter, chilling, further processing, and packaging for export to Canada."

Beef identified as being derived from cattle of Canadian origin may be shipped between official plants under seal as prescribed in Section 312.5(a) of the regulations, if accompanied by an MP Form 408. Identity of fresh or processed product must be further maintained at receiving plants if intended for export to Canada. Time involved for inspection procedures other than those required by the regulations and/or the Manual is reimbursable (See Part 350 of the regulations and Section 26.2 of the Manual).

(3) Eligible countries. Products originating in the following countries only are permitted entry into Canada: Argentina, Australia, Belgium, Botswana (Bechuanaland), Brazil, Bulgaria, Czechoslovakia, Federal Republic of Germany, France, Hungary, Iceland, Republic of Ireland, Italy, Netherlands, New Zealand, Northern Ireland, Norway, Paraguay, People's Republic of Poland, Portugal, Scotland (approved slaughterhouses at Edinburgh, Glasgow, Dundee and Aberdeen), Republic of South Africa, Sweden, Switzerland, United States of America, Uruguay, Yugoslavia, Kenya, China, and Romania.

(4) Descriptive terms. Descriptive terms applied to meat or meat product must be consistent with Canada Food and Drug Regulations, and its Meat Inspection Regulations.

(5) Eligible product.

(i) Carcass. Carcasses, sides, or quarters must be intact. Those with trimmed areas, severed joints, missing parts, and removed peritoneum, pleura, or body lymph nodes, are unacceptable.

(ii) Beef hearts. Make at least four incisions into cut surfaces of the interventricular septum, and inner surfaces of ventricles.

(iii) Livers. Hepatic lymph nodes shall be intact. Sliced livers in consumer-size packages are accepted without such nodes.

(iv) Spleens, lungs, udders, etc. Spleens, lungs, udders, mucous membranes, and parotid salivary glands are prohibited in meat food products.

(v) Sausage. Antioxidants and soya products are not permitted in sausage. Sausage cereal content must comply with Section B 14.030 of Canada Food and Drug Regulations stating that "No person shall sell prepared meat or prepared

meat byproducts that contains more than (a) that amount of filler, meat binder, or other ingredients that is represented by 4 percent reducing sugars, calculated as dextrose as determined by official method, or (b) 60 percent moisture where such prepared meat or prepared meat product contains filler." Export certificates will be signed only when product meets these requirements.

(vi) Casings. Issue MP Form 415-5 in duplicate. Show official plant number(s) where product was prepared, consignor's name, and address.

Animal casings must be slimed, stripped, and mucous lining completely removed by means other than fermentation. Markings must be approved by the Veterinary Director General.

(vii) Inedible (R). The following statement will be made on MP Form 415-3: "The material described on this form originated in a plant operating under U.S. Federal inspection and was from animals that received ante- and post-mortem inspection and were found free of disease at time of slaughter." Inedible meat products must be identified with finely powdered charcoal or with Birkoline-B and must be labeled as follows:

Decharacterized--(Product name)
inedible, unfit for food.
Packer's name and address.
Establishment number without
official inspection legend.
Net Weight _____ lbs.
"Keep refrigerated," or "Keep
frozen," whichever is applicable.
Country of origin.

Each container must be identified with MP Form 415-6, and the numbers of such forms must be entered on MP Form 415-3.

For label approval, see 22.23(c)(4) (i).

(6) Prohibited importation. The following importations are prohibited:

- a. Meat from boars.
- b. Meat trimmings too small to

permit adequate inspection.

c. Pork skins (attached and detached) with black hair roots.

d. Product with freezer burns or areas of dehydration.

e. Artificially colored product.

f. Meat inspected or identified under Part 350 of the regulations.

(7) Container and markings. Meat products packed in cartons with ventilation or hand holes are not accepted. Bulk product--primal cuts such as pork hams, skinless pork bellies, etc.--must be individually stamped with the USDA inspection legend. Fresh pork cuts may be shipped in combo bins or cartons printed with all mandatory information on one main panel except that product name can be printed, rubber stamped, stenciled, or applied by a pressure sensitive sticker. Frozen pork cuts are permitted entry only in properly packaged shipping cartons. Truckload or carload lots of dressed hogs may be identified by a placard marking. Each hog carcass side must be stamped with three legend brands. Beef quarters, in addition to three brands for each quarter, and both skin-on and skinless calves must be provided with identification by a shipping tag printed with all mandatory information on one side and having a serially numbered USDA export stamp affixed to the other side of the tag. Carload lots of shortening, lard, or tallow must be identified by a placard and be consigned directly to a registered plant in Canada operating under the Canada Meat Inspection Act and Regulations.

(8) Placard. Mandatory information for loose or bulk meat must appear on a placard 12" x 12" on doors of railroad cars, trucks, or trailers, and must show:

a. Name and address of packer or first dealer. The address shall include the abbreviation "USA." In case of first dealer or distributor, the name shall be preceded by the words "Packed For."

b. True and correct description of contents. Animal species must be shown with cut or portion name.

c. "Product of USA" immediately below product description. Usually, this requires letters at least half the size of those used in product name, and must be legible.

d. Net weight. The word "weight" must be spelled in full.

e. MP Form 412-10 must be attached to each container.

(c) Poultry Products

(1) Export stamps. Apply MP Form 412-10 to each shipping container of poultry and/or poultry products. On MP Form 506 mark out "Each container stamped with USDA Certificate." List stamp numbers in "other box markings" block.

(2) Kidney removal. Kidneys must be removed from all edible poultry brought into Canada, and export certificates covering such product must include a proper statement. To comply, type the following in remarks block of MP Form 506: "Kidneys have been completely removed from poultry covered by this certificate."

(3) Containers. When poultry is processed with kidneys removed, containers should be clearly marked by lot number, or by other acceptable means to be readily identifiable when shipped. Record all marks (or lot numbers) placed on containers. Also record where and when poultry was stored, and name of inspector present during the procedure.

Firms processing poultry with kidneys removed should be encouraged to include the words "kidneys removed" on printed labels. When packages are not so labeled, the inspector shall examine the product to assure that kidneys were removed even when representative sample defrosting is required.

(4) Labeling.

(i) Approval. Before shipping, exporters shall obtain Canadian and USDA approval of all product labels (edible and inedible) for immediate and shipping containers by sending proof of proposed labels to:

Director
Meat Inspection Division
Health of Animals Branch
Department of Agriculture
Ottawa, Canada

For U.S. approval, labels shall be sent to STS-LP.

(ii) Shipping container. Poultry products packed in cartons with ventilation or hand holes are not accepted. * Information on main panel of shipping container must include: *

1. Complete name and address of plant.
2. Plant number--this may be in the "USDA inspected for wholesomeness" official inspection mark, provided it is readily legible or near the official inspection mark on main panel.
3. Name of product and number of birds in the shipping container.
4. Grade mark of country of origin.
5. The words "Product of USA" under common name of product.
6. The words "Net Weight."
7. The USDA inspected for wholesomeness official inspection mark.
8. A statement indicating "for further processing," if applicable.
9. "Keep refrigerated," or "Keep frozen," whichever is applicable.

(iii) U.S. trade requirement. Boxes printed for U.S. trade requirements are satisfactory, provided printing size is in reasonable relation to box size. Requirements in Canadian poultry regulations are recommended as a guide.

Main panel--items to be printed:

1. Name and address of plant.
2. "Net Weight."
3. "Product of USA."
4. "USDA inspected for wholesomeness official inspection mark." This may be printed on the box or on a printed label glued to the box.

The following items may be stencilled or stamped on main panel of shipping container:

1. Name of product and number of birds in the box.
2. Grade mark.
3. Plant number. If plant number, included is printed "USDA inspected for wholesomeness official inspection mark," is of sufficient size to be easily read, it will suffice; otherwise, it may be stenciled or stamped near the official inspection mark elsewhere on the panel.
4. When product is for further processing, suitable words so indicating shall appear on box panel.

(iv) Utility grade poultry. When grading and labeling "utility" grade poultry for export to Canada, grade will be shown as "grade utility" in letters at least 1/2 inch, with the phrase "for further processing" shown directly below the grade.

Shipping container. Shipping container will be stamped with export stamp and USDA grade utility stamp. These stamp impressions shall be on left side or lower part of label.

Ready-to-cook. Grade utility specifications for ready-to-cook fowl, chickens, and turkeys will be used only when grading ready-to-cook poultry for export to Canada.

(v) Box-packed poultry. Figure 22.1 shows a sample of shipping container markings for box-packed poultry and poultry products to Canada.

Size of letters in kind name "for further processing (when required)" and grade letter--at least 1/2 inch.

Size of letters in net weight--at least 1/4 inch.

Size of letters in "Product of USA"--not less than 1/2 the size of letters in kind name.

Kind Name:

Chickens	Young Ducks
Chicken Capons	Mature Ducks
Fowl	Young Geese
Young Turkeys	Mature Geese
Mature Turkeys	

(vi) Polyfilm bags. They must be clear (semiopaque bags are not acceptable) and show:

1. Name and address of packer or first dealer. If the latter is used, the words "Packed For" must precede first dealer's name. Address may be the local or head office and must include the abbreviations "USA." If head office address is used, it must be so stated.

2. Name of product.

3. Official U.S. Grade mark.

4. "Product of USA" shown clearly and boldly with letters at least 1/2 the height of the tallest letter in product name.

5. Official inspection mark and plant number.

6. Net weight.

7. Plant number, which may be shown within the inspection mark or on a flat clip. The letter "P" shall be shown above plant number.

Exporters must submit bags and bag-closure clips (if used) to Canadian authorities for approval.

(5) Processed product; phosphates. Canadian regulations have no provisions for addition of phosphates to manufactured poultry products. Thus, products with phosphates shall not be certified and exported to Canada.

(6) Backs, necks for animal food. Backs and/or necks may be exported to Canada for animal food purposes under the following conditions:

(3) Certification. Issue MP Form 506, MP Form 81, and MP Form 82. These forms must be signed by an MPI Veterinarian. The name of the ship by which the product is transported should be shown on MP Form 82 and on MP Form 506 (under "remarks").

22.31 GERMANY (EAST GERMANY)

(a) Meat Byproducts

Use MP Form 412-3. Upon plant's request, the MPI veterinarian signing the certificate may certify and sign on its reverse side the following required information:

1. Byproducts were produced in plants under constant veterinary supervision.

2. Animals, from which byproducts were obtained, originate from stock free of acute animal epidemics--hog pest, hoof-and-mouth disease, etc.--during the last 3 months.

3. Animals from which byproducts were obtained were examined by a veterinarian, before and after slaughter, and were found healthy.

4. Territories through which swine were transported to port of loading, and port of loading itself, were not subject to any traffic restrictions for swine pest and hoof-and-mouth disease.

5. Byproducts are fit for human consumption without any restrictions, and do not contain any preservatives.

6. Wrapping material used is acceptable from a veterinary hygienic viewpoint.

7. Means of transportation have been disinfected with procedure recognized by legal authority. Means of transportation and condition of loading correspond to minimum requirements.

* 8. Animals from which byproducts were
* obtained were not treated with estro-
* gens, hormones or other active sub-
* stances, nor with sedatives forming
* residues in the organism which are

dangerous to human health. *

Hog cholera restriction. Hog pest is the European term for hog cholera. Pork byproducts must be obtained from hogs that (1) originate in States with a quarantine program for hog cholera, and (2) are free of hog cholera quarantine restrictions when shipped for slaughter.

(b) Poultry Products

On an individual request basis, veterinary inspectors may state on export certificates covering shipments passing through East Germany

22.67 VENEZUELA**(a) Meat Products**

Pork. The following certification in Spanish and English may be added to the reverse of the regular export certificate or on letterhead stationery:

"I certify that the product shipped under the certificate has been processed by a method, approved by the United States Department of Agriculture, which is adequate to destroy any possible live trichinae. I further certify that this product has been held in a freezer for a period of not less than 30 days at a temperature not in excess of 5° F."

(Signature)

"Yo certifico que el producto enviado y amparado por este certificado ha sido processado por metodos aprobados por el Departamento de Agricultura de los Estados Unidos y que son adecuados para destruir cualquier tricquina que pudiera existir. Asimismo certifico que este producto ha sido mantenido en un congelador durante un periodo no menor de 30 dias y a una temperatura no excediendo 5 grados Fahrenheit."

A variation of the certificate describing other methods of treating pork for trichinae may be issued. However, accurate Spanish translation must be provided.

(b) Poultry Products

Issue MP Form 506.

22.67-A YUGOSLAVIA**Meat Products**

- * Issue MP Form 412-3, and the additional certification typed on USDA/
- *APHIS letterhead stationery as follows:

VETERINARY CERTIFICATE

Certificate No. _____
(Serial No. of accompanying MP Form 412-3).

1. The (product name) described herein comes from (species) which were inspected before and after slaughter and were found free of contagious diseases.

2. The preparation and freezing of the product described herein has been accomplished in establishments under constant veterinary inspection.

3. The products in this shipment are suitable, after defrosting, for manufacture into products for human consumption.

Signed _____
Veterinary Medical Officer

22.68 WESTERN SAMOA**Poultry Products**

Only veterinary inspectors will issue Form MP 506 for ready-to-cook poultry.

PART 23

LABORATORY SERVICES

CHEMISTRY

Subpart 23-A

(Regs: M-318; P-Subpart O)

23.1 CHEMISTRY LABORATORIES

(a) Type of Analysis

Chemistry laboratories conduct general chemical analysis of meat and/or poultry products to determine moisture, protein, salt, nitrite, nitrate, total fat, animal fat, etc. They also analyze products for biological residues, nonmeat or non-poultry food additives, and various chemical compounds used in federally inspected plants.

(b) MPI Laboratory

Laboratories serving designated geographical areas and their code numbers are:

San Francisco, California	0601
Washington, D.C.	1101
Athens, Georgia	1301
Kansas City, Kansas	2001
St. Louis, Missouri	2901
Omaha, Nebraska	3101
Peoria, Illinois	1702

Address and telephone number of these laboratories may be found in the "Working Reference" (Directory of Meat and Poultry Inspection Program Establishments, Circuits and Officials).

(c) AQC Laboratory

A plant or commercial laboratory approved by STS-SDS to analyze samples

in conjunction with approved quality control systems.

(d) Certified Laboratory

A plant or commercial laboratory certified by STS-CH for analysis of only water, protein, salt and fat in meat and/or poultry products.

The inspector may use results from certified laboratory with same authority as from an MPI laboratory.

Name, address, and telephone number of certified laboratories are listed in the working reference.

(1) Companion and verification samples. When a plant elects to use a certified laboratory and is under lot inspection, the inspector should submit companion samples to MPI laboratory to determine the certified laboratory's continued analytical capability. He shall submit about 25 percent of the samples sent to the certified laboratory and withhold identity of such samples from certified laboratory and plant.

When a plant is under AQC, verification samples are submitted to MPI laboratory to determine accuracy of such control.

(2) Correlation of Results. MPI laboratories shall summarize companion sample results biweekly and send a copy to STS-CH.

Certified laboratories shall summarize official sample results and report them biweekly to STS-CH on Form MP 19, which will be signed also by the inspector, if the certified laboratory is a plant laboratory.

The two sets of results will be matched by computer.

When insufficient correlation exists between paired samples or when official

"held" lot, the inspector must, if sample results are:

1. Equal or below required ratio, accept the lot.

2. Above allowed ratio, refuse entry.

3. Above required and below allowed ratios, submit two more samples. If neither of these two samples is above allowed ratio and the 3-sample average equals or is below required ratio, accept the lot. If either of the two samples is above allowed ratio or the 3-sample average is above required ratio, refuse entry.

(h) VS Responsibility

Above procedure and table on moisture-protein ratio shall not be applied to any product where VS regulations indicate a restricted ratio.

Violations involving VS will immediately be directed to the nearest VS representative for instructions.

DISPOSITION

Subpart 27-D

(Regs: M-314, 327; P-Subpart L, T)

Disposition of imported product is based upon compliance with MPI and/or VS requirements.

27.18 NONINSPECTED PRODUCT

Imported product not offered for inspection should be referred to U.S. Customs and other interested officials.

Refused entry disposition should not be made for any shipment or portion of shipment (short shipped or sorted) not presented for inspection.

27.19 MP FORM 410

See Chart 20.1. Section E of this form shall be completed, signed, and dated by the inspector completing the examination.

Products held for sample results or those under active appeal are not considered complete.

When a shipment has been inspected and totally passed, the inspector will initial each entry.

When a shipment or a portion of a shipment is refused entry, the inspector will identify amounts, rejection codes, and disposition.

(a) Codes

Correct country, product, and rejection codes shall be entered on MP Form 410 as required.

(1) Country codes. See Table 27.7.

(2) Product codes. They are on MP Form 410 (cover sheet). Use them to categorize each shipment entered.

Identify products not specifically coded with "canned (other)," "miscellaneous," and "poultry (other)" codes as grouped below:

1. Canned (other) - canned meat products other than beef, and canned meat and poultry products with more meat than poultry.

2. Miscellaneous - meat products not processed in cans or covered by other codes.

3. Poultry Products (other) - poultry products not covered by other codes, and poultry and meat products with more poultry than meats.

(3) Rejection codes. See Table 27.8.

(b) Distribution

MP Form 410 must be distributed as soon as possible and not later than 5 days after inspection is completed. The number 2 copy must be sent to the Des Moines MPI Data Services Center with a copy of the health certificate.

Control of refused shipments until final disposition--shipping out of the

Table 27.7 - Country codes

Argentina	150	Germany	390	Northern Ireland	925I
Australia	160	Guatemala	415	Norway	685
Austria	165	Haiti	420	Panama	710
Belgium	190	Honduras	430	Paraguay	715
Brazil	220	Hong Kong	435	Poland	730
Bulgaria	245	Hungary	445	Rumania	755
Canada	260	Iceland	450	Scotland	925S
Colombia	285	Ireland (Eire)	470	Spain	830
Costa Rica	295	Italy	480	Sweden	850
Czechoslovakia	310	Japan	490	Switzerland	855
Denmark	315	Luxembourg	570	Trust Territory	900
Dominican Republic	320	Mexico	595	of Pacific	.
El Salvador	330	Netherlands	630	Uruguay	930
England-Wales	925E	(Holland)		Venezuela	940
Finland	340	New Zealand	660	Yugoslavia	970
France	350	Nicaragua	665		

United States, destruction or conversion to animal foods--will be maintained and recorded on copies 1, 3 and 4.

After final disposition, all copies will be distributed and product entry is considered closed.

27.20 PASSED SHIPMENT; MARKING

Each shipping container, carcass, or individually shipped part shall be stamped with the 2 1/2 inch "U.S. Inspected and Passed" import brand. Such marked product can freely move in commerce.

Containers of horsemeat shall have the word "horsemeat" in letters not less than 1/2 inch high. The import brand shall be stamped adjacent to such word.

(a) Marking Before Inspection

The privilege of stamping lots (Insp'd & Ps'd) before inspection is completed may be extended, provided (1) such lots are stored in immediate facility, and (2) an importer's letter is on file at the MPI import office, stating the request and understanding that, if such lots are refused entry, stamps will be removed. Inspector's time to observe stamp removal must be reimbursed.

(b) Unacceptable Product

If inspected, passed, and released

imported product is found to be unacceptable, it shall be retained and handled as domestic product. FO-FP shall be informed. Products outside MPI jurisdiction shall be reported to FO-CS for appropriate action.

(c) Unmarked Sampled Product

Sampling may often result in certain amounts of unmarked product left from accepted lots. Such product is

Table 27.8 - Rejected codes

Rejection cause	Code
Contamination (dirt, hair, feces, ingesta, etc.)	01
Processing defects (bones, bruises, clots, etc.)	02
Unsound condition	03
Pathological defects	05
Labeling defects	07
Composition/standard	09
VS requirements	10
Residues	11
Miscellaneous	12
Container condition (defects)	13



UNITED STATES DEPARTMENT OF AGRICULTURE
Animal and Plant Health Inspection Service
Meat and Poultry Inspection Program
Washington, D.C. 20250



MEAT AND POULTRY INSPECTION REGULATIONS

CHANGE: 76-11

November 1976

MAINTENANCE INSTRUCTIONS

Remove Page	Insert Page	Numbered
SUBCHAPTER A - MANDATORY MEAT INSPECTION		
vii	vii	76-11
viii	viii	76-11
20a	20a	76-11
77	77	76-11
78	78	76-11
135	135	76-11
136	136	76-11
136a	---	
136b	---	
143	143	76-11
143a	143a	76-11
181	181	76-11
182	182	76-11

Remove Page	Insert Page	Numbered
SUBCHAPTER B - VOLUNTARY INSPECTION AND CERTIFICATION SERVICE		
3	3	76-11
4	4	76-11
7	7	76-11
8	8	76-11
25	25	76-11
26	26	76-11
47	47	76-11
48	48	76-11
61	61	76-11
SUBCHAPTER C - MANDATORY POULTRY PRODUCTS INSPECTION		
23	23	76-11
24	23	76-11

- 317.10 Reuse of official inspection marks; reuse of containers bearing official marks, labels, etc.
- 317.11 Labeling, filling of containers, handling of labeled products to be only in compliance with regulations.
- 317.12 Relabeling products; requirements.
- 317.13 Storage and distribution of labels and containers bearing official marks.
- 317.14 Reporting of obsolete labels.
- 317.15 [Reserved]
- 317.16 Labeling and containers of custom prepared products.
- 317.17 Interpretation and statement of labeling policy for cured products.
- 317.18 [Reserved]
- 317.19 Jar closures requirements.

PART 318-ENTRY INTO OFFICIAL ESTABLISHMENTS: REINSPECTION AND PREPARATION OF PRODUCTS

- Sec.
- 318.1 Products and other articles entering official establishments.
- 318.2 Reinspection, retention, and disposal of meat and poultry products at official establishments.
- 318.3 Designation of places of receipt of products and other articles for reinspection.
- 318.4 Preparation of products to be officially supervised; responsibilities of official establishments.
- 318.5 Requirements concerning procedures.
- 318.6 Requirements concerning ingredients and other articles used in preparation of products.
- 318.7 Approval of substances for use in the preparation of products.
- 318.8 Preservatives and other substances permitted in product for export only; handling; such product not to be used for domestic food purposes.
- 318.9 Samples of products, water, dyes, chemicals, etc., to be taken for examination.
- 318.10 Prescribed treatment of pork and products containing pork to destroy trichinae.
- 318.11 Canning with heat processing and hermetically sealed containers; cleaning containers; closure; code marking; heat processing; incubation.
- 318.12 Manufacture of dog food or similar uninspected article at official establishments.
- 318.13 Mixtures containing product but not amenable to the Act.
- 319.14 Adulteration of product by polluted water, etc.; procedure for handling.
- 318.15 Tagging chemicals, preservatives, cereals, spices, etc., "U.S. retained."
- 318.16 Pesticide chemicals and other residues in products.

PART 319-DEFINITIONS AND STANDARDS OF IDENTITY OR COMPOSITION

Subpart A--General

- Sec.
- 319.1 Labeling and preparation of standardized products.

Subpart B--Raw Meat Products

- 319.15 Miscellaneous beef products.
- 319.29 Miscellaneous pork products.

Subpart C--Cooked Meats

- 319.80 Barbecued meats.
- 319.81 Roast beef parboiled and steam roasted.

Subpart D--Cured Meats, Unsmoked and Smoked

- 319.100 Corned beef.
- 319.101 Corned beef brisket.
- 319.102 Corned beef round and other corned beef cuts.
- 319.103 Cured beef tongue.
- 319.104 Cured pork products, unsmoked or smoked.
- 319.105 Chopped ham.

Subpart E--Sausage Generally: Fresh Sausage

- 319.140 Sausage.
- 319.141 Fresh Pork sausage.
- 319.142 Fresh Beef sausage.
- 319.143 Breakfast sausage.
- 319.144 Whole hog sausage.

Subpart F--Uncooked, Smoked Sausage

- 319.160 Smoked pork sausage.

Subpart G--Cooked Sausage

- 319.180 Frankfurter, wiener, vienna, bologna, garlic bologna, knockwurst, and similar products.
- 319.181 Cheesefurters and similar products.
- * 319.182 Liver sausage and braunschweiger.

Subpart H--[Reserved]

Subpart I--Semi-Dry Fermented Sausage
[Reserved]

Subpart J--Dry Fermented Sausage
[Reserved]

Subpart K--Luncheon Meat, Loaves and Jellied Products

- 319.260 Luncheon meat.
- 319.261 Meat loaf.

such a request will result in overtime service at the start of the following day: Provided, That an inspector may be recalled to his assignment after completion of his daily tour of duty under the provisions of §307.6(b).

§ 307.5 Overtime and holiday inspection service.

(a) The management of an official establishment, an importer, or an * exporter shall pay the Animal and Plant Health Inspection Service \$13.20 per * hour per Program employee to reimburse the Program for the cost of the inspection service furnished on any holiday as specified in paragraph (b) of this section; or for more than 8 hours on any day, or more than 40 hours in any administrative workweek Sunday through Saturday.

(b) Holidays for Federal employees shall be New Year's Day, January 1; Washington's Birthday, the third Monday in February; Memorial Day, the last Monday in May; Independence Day, July 4; Labor Day, the first Monday in September; Columbus Day, the second Monday in October; Veterans' Day, the fourth Monday in October; Thanksgiving Day, the fourth Thursday in November; Christmas Day, December 25. When any of the above-listed holidays falls outside the basic workweek, the nearest workday within that week shall become a holiday.

§ 307.6 Basis of billing for overtime and holiday services.

(a) Each recipient of overtime or holiday inspection service, or both, shall be billed, at the rate established in § 307.5(a), in increments of quarter hours. For billing purposes, 8 or more minutes shall be considered a full quarter hour. Billing will be for each quarter hour service rendered by each Program employee.

(b) Official establishments, importers, or exporters requesting and receiving the services of a Program employee after he has completed his day's assignment and left the premises, or called back to duty during any overtime or holiday period, shall be billed for a minimum of 2 hours overtime or holiday inspection service at the established rate.

(c) Bills are payable upon receipt and become delinquent 30 days from the date of the bill. Overtime or holiday inspection will not be performed for anyone having a delinquent account.

THE REVERSE OF THIS PAGE IS INTENDED TO BE BLANK.

(3) The name and place of business of the manufacturer, packer, or distributor for whom the product is prepared, as prescribed in paragraph (g) of this section;

(4) An accurate statement of the net quantity of contents, as prescribed in paragraph (h) of this section;

(5) An official inspection legend and, except as otherwise provided in paragraph (i) of this section, the number of the official establishment, in the form required by Part 312 of this subchapter;

(6) Any other information required by the regulations in this part or Part 319 of this subchapter.

(d) The principal display panel shall be the part of a label that is most likely to be displayed, presented, shown, or examined under customary conditions of display for sale. Where packages bear alternate principal display panels, information required to be placed on the principal display panel shall be duplicated on each principal display panel. The principal display panel shall be large enough to accommodate all the mandatory label information required to be placed thereon by this part and Part 319 of this subchapter with clarity and conspicuousness and without obscuring of such information by designs or vignettes or crowding. In determining the area of the principal display panel, exclude tops, bottoms, flanges at tops and bottoms of cans, and shoulders and necks of bottles or jars. The principal display panel shall be:

(1) In the case of a rectangular package, one entire side, the area of which is at least the product of the height times the width of that side.

(2) In the case of a cylindrical or nearly cylindrical container:

(i) An area that is 40 percent of the product of the height of the container times the circumference of the container, or (ii) a panel, the width of which is one-third of the circumference and the height of which is as high as the container: Provided, however, That if there is immediately to the right or left of such principal display panel, a panel which has a width not greater than 20 percent of the circumference and a height as high as the container, and which is reserved for information prescribed in subparagraphs (c)(2), (3) and (5), such panel shall be known as the "20 percent panel" and such information may be shown on that panel in lieu of showing it on the principal display panel, as provided in subparagraphs (f)(3), (g)(2), and (i)(8) and (9).

(3) In the case of a container of any other shape, 40 percent of the total surface of the container.

(e) Any descriptive designation used as a product name for a product which has no common or usual name shall clearly and completely identify the product. Product which has been prepared by salting, smoking, drying, cooking, chopping, or otherwise shall be so described on the label unless the name of the product implies, or the manner of packaging shows that the product was subjected to such preparation. The unqualified terms "meat," "meat byproduct," "meat food product," and terms common to the meat industry but not common to consumers such as "picnic," "butt," "cal," "square," "loaf," "spread," "delight," "roll," "plate," "luncheon," and "daisy" shall not be used as names of a product unless accompanied with terms descriptive of the product or with a list of ingredients, as deemed necessary in any specific case by the Administrator in order to assure that the label will not be false or misleading.

(f) (1) The list of ingredients shall show the common or usual names of the ingredients arranged in the descending order of predominance, except as otherwise provided in this paragraph.

(i) The term "flavorings" may be used to designate natural spices, essential oils, oleoresins and other natural spice extractives, and the term "spices" may be used to designate natural spices, without naming each.

(ii) The term "corn syrup" may be used to designate either corn syrup or corn syrup solids.

(iii) The term "animal and vegetable fats" or "vegetable and animal fats" may be used to designate the ingredients of mixtures of such edible fats in product designated "compound" or "shortening." "Animal fats" as used herein means fat derived from inspected and passed cattle, sheep, swine, or goats.

(iv) When a product is coated with pork fat, gelatin, or other approved substance and a specific declaration of such coating appears contiguous to the name of the product, the ingredient statement need not make reference to the ingredients of such coating.

(v) When two meat ingredients comprise at least 70 percent of the meat and meat byproduct ingredients of a formula and when neither of the two meat ingredients is less than 30 percent by weight of the total meat and meat byproducts used, such meat ingredients may be interchanged in the formula without a change being made in the ingredients statement on labeling materials: Provided, That the word "and" in lieu of a comma shall be shown between the * declaration of such meat ingredients in the statement of ingredients. *

(2) On containers of frozen dinners, entrees, pizzas, and similar consumer packaged products in cartons the ingredient statement may be placed on the front riser panel: Provided, That the words "see ingredients" followed immediately by an arrow is placed on the principal display panel immediately above the location of such statement without intervening print or designs.

(3) The ingredient statement may be placed on the 20 percent panel adjacent to the principal display panel and reserved for required information, in the case of a cylindrical or nearly cylindrical container.

(g) (1) The name or trade name of the person that prepared the product may appear as the name of the manufacturer or packer without qualification on the label. Otherwise the name of the distributor of the product shall be shown with a phrase such as "Prepared for * * *." The place of business of the manufacturer, packer, or distributor shall be shown on the label by city, State, and postal ZIP code when such business is listed in a telephone or city directory, and if not listed in such directory, they the place of business shall be shown by street address, city, State, and postal ZIP code.

(2) The name and place of business of the manufacturer, packer, or distributor may be shown:

(i) On the principal display panel or

(ii) On the 20 percent panel and adjacent to the principal display panel and reserved for required information, in the case of a cylindrical or nearly cylindrical container, or

(iii) On the front riser panel of frozen food cartons.

one-half of 1 percent available chlorine (5,000 parts¹ per million or other equivalent disinfectant approved by the Administrator¹ shall be applied to the surface of the rooms and equipment and rinsed with potable water before use.

(c) Hermetically sealed containers of product which have been contaminated by polluted water shall be examined promptly by the official establishment under supervision of an inspector and rehandled as follows:

(1) Separate and condemn all product in damaged or extensively rusted containers.

(2) Remove paper labels and wash the remaining containers in warm soapy water, using a brush where necessary to remove rust or other foreign material. Disinfect these containers by either of the following methods:

(i) Immerse in a solution of sodium hypochlorite containing not less than 100 parts per million of available chlorine or other equivalent disinfectant approved by the Administrator,¹ rinse in potable water, and dry thoroughly; or

(ii) Immerse in 212° F. water, bring temperature of the water back to 212° F. and maintain the temperature at 212° F. for 5 minutes, then remove containers from water and cool them to 95° F. and dry thoroughly.

(3) After handling as described in subparagraph (2) of this paragraph, the containers may be relacquered, if necessary, and then relabeled with approved labels applicable to the product therein.

(4) The identity of the canned product shall be maintained throughout all stages of the rehandling operations to insure correct labeling of the containers.

§ 318.15 Tagging chemicals, preservatives, cereals, spices, etc., "U.S. retained."

When any chemical, preservative, cereal, spice, or other substance is intended for use in an official establishment, it shall be examined by a Program employee and if found to be unfit or otherwise unacceptable for the use intended, or if final decision regarding acceptance is deferred pending laboratory or other examination, the employee shall attach a "U.S. retained" tag to the substance or container thereof. The substance so tagged shall be kept separate from other substances as the circuit supervisor may require and shall not be used until the tag is removed, and such removal shall be made only by a Program employee after a finding that the substance can be accepted, or, in the case of an unacceptable substance, when it is removed from the establishment.

§ 318.16 Pesticide chemicals and other residues in products.

(a) Nonmeat ingredients. Residues of pesticide chemicals, food additives and color additives or other substances in or on ingredients (other than meat, meat byproducts, and meat food products) used in the formulation of products

¹ A list of approved disinfectants is available upon request to Scientific Services, Meat and Poultry Inspection Program, Animal and Plant Health Inspection Service, U.S. Department of Agriculture, Washington, D.C. 20250.

shall not exceed the levels permitted under the Federal Food, Drug, and Cosmetic Act, and such nonmeat ingredients must otherwise be in compliance with the requirements under that Act.

(b) Products, and meat, meat byproduct, or other meat food product ingredients. Products, and products used as ingredients of products, shall not bear or contain any pesticide chemical, food additives, or color additive residue in excess of the level permitted under the Federal Food, Drug, and Cosmetic Act and the regulations in this subchapter, or any other substance that is prohibited by such regulations or that otherwise makes the products adulterated.

(c) Standards and procedures. Instructions specifying the standards and procedures for determining when ingredients of finished products are in compliance with this section shall be issued to the inspectors by the Administrator. Copies of such instructions will be made available to interested persons upon request made to the Administrator.

PART 319-DEFINITIONS AND STANDARDS OF IDENTITY OR COMPOSITION

AUTHORITY: The provisions of this Part 319 issued under sec. 21, Federal Meat Inspection Act, as amended by the Wholesome Meat Act (21 U.S.C. Supp., sec. 601 et seq.), and Public Law 91-342; Talmadge-Aiken Act of Sept. 28, 1962 (7 U.S.C. 450); Act of July 24, 1919 (7 U.S.C. 394); subsection 21(b), Federal Water Pollution Control Act, as amended by Public Law 91-224 and by other laws.

Subpart A-General

§ 319.1 Labeling and preparation of standardized products.

Labels for products for which standards of identity or composition are prescribed in this part shall show the appropriate product name, an ingredient statement, and other label information in accordance with the special provisions, if any, in this part, and otherwise in accordance with the general labeling provisions in Part 317 of this subchapter, and such products shall be prepared in accordance with the special provisions, if any, in this part and otherwise in accordance with the general provisions in this subchapter. Any product for which there is a common or usual name must consist of ingredients and be prepared by the use of procedures common or usual to such products insofar as specific ingredients or procedures are not prescribed or prohibited by the provisions of this subchapter.

* * * * *

Subpart B-Raw Meat Products

§ 319.15 Miscellaneous beef products.

(a) Chopped beef, ground beef. "Chopped Beef" or "Ground Beef" shall consist of chopped fresh and/or frozen beef with or without seasoning and without the addition of beef fat as such, shall not contain more than 30 percent fat, and shall not contain added water, binders, or extenders. When beef cheek meat (trimmed beef cheeks) is used in the preparation of chopped or ground beef, the amount of such cheek meat shall be limited to 25 percent; and

may be used to facilitate chopping or mixing or to dissolve the curing and seasoning ingredients, but the sausage shall contain no more than 10 percent of added water. These sausage products may contain uncooked, cured pork which does not contain any phosphates or contains only phosphates approved under Part 318 of this chapter. These sausage products may contain poultry products, individually or in combination, not in excess of 15 percent of the total ingredients, excluding water, in the sausage. Such poultry products shall not contain kidneys or sex glands. The amount of poultry skin present in the sausage must not exceed the natural proportion of skin present on the whole carcass of the kind of poultry used in the sausage, as specified in § 381.117(d) of this chapter. The poultry products used in the sausage shall be designated in the ingredient statement on the label of such sausage in accordance with the provisions of § 381.118 of this chapter. Meat byproducts used in the sausage shall be designated individually in the ingredient statement on the label for such sausage in accordance with § 317.2 of this chapter.

(c) A cooked sausage as defined in paragraph (a) of this section shall be labeled by its generic name, e.g., frankfurter, frank, furter, hotdog, wiener, vienna, bologna, garlic bologna, or knockwurst. Sausage products within paragraph (a) that are prepared with meat from a single species of cattle, sheep, swine, or goats shall be labeled with the term designating the particular species in conjunction with the generic name, e.g., "Beef Frankfurter."

(d) A cooked sausage as defined in paragraph (b) of this section shall be labeled by its generic name, e.g., frankfurter, frank, furter, hotdog, wiener, vienna, bologna, garlic bologna, or knockwurst, in conjunction with the phrase "with byproducts" or "with variety meats" with such supplemental phrase shown in a prominent manner directly contiguous to the generic name and in the same color on an identical background.

(e) With appropriate labeling as required by § 317.8(b)(16) of this chapter, e.g., "Frankfurter, Calcium Reduced Dried Skim Milk Added," or "Bologna, with Byproducts (or Variety Meats), Soy Flour Added," one or more of the following binders may be used in cooked sausage otherwise complying with paragraph (a) or (b) of this section: dried milk, calcium reduced dried skim milk, nonfat dry milk, cereal, vegetable starch, starchy vegetable flour, soy flour, soy protein concentrate and isolated soy protein, provided such ingredients, individually or collectively, do not exceed 3 1/2 percent of the finished product, except that 2 percent of isolated soy protein shall be deemed to be the equivalent of 3 1/2 percent of any one or more of the other binders.

(f) Cooked sausages shall not be labeled with terms such as "All Meat" or "All (Species)," or otherwise to indicate they do not contain nonmeat ingredients or are prepared only from meat.

(g) For the purposes of this section: Poultry meat means deboned chicken meat or turkey meat, or both, without skin or added fat; poultry products mean chicken or turkey, or chicken meat or turkey meat as defined in § 381.118 of this chapter, or poultry byproducts as defined in § 381.1 of this chapter; and meat byproducts (or variety meats) mean pork stomachs or snouts; beef, veal, lamb or goat tripe; beef, veal, lamb, goat or pork hearts, tongues, fat, lips, weasands and spleens; and partially defatted pork fatty tissue, or partially defatted beef fatty tissue.

§ 319.181 Cheesefurters and similar products.

"Cheesefurters" and similar products are products in casings which resemble frankfurters except that they contain sufficient cheese to give definite characteristics to the finished article. They may contain cereal, vegetable starch, starchy vegetable flour, soy flour, soy protein concentrate, isolated soy protein, nonfat dry milk, calcium reduced skim milk, or dried milk. The finished product shall contain no more than 3.5 percent of these additives, individually and collectively, exclusive of the cheese constituent. In determining the maximum amount of the ingredients specified in this subparagraph which may be used, individually and collectively, in a product, 2 percent of isolated soy protein shall be considered the equivalent of 3.5 percent of any other ingredient specified in this subparagraph. When any such additive is added to these products, there shall appear on the label in a prominent manner, contiguous to the name of the product, the name of each such added ingredient, as for example, "Cereal Added," "With Cereal," "Potato Flour Added," "Cereal and Potato Flour Added," "Soy Flour Added," "Nonfat Dry Milk Added," "Cereal and Nonfat Dry Milk Added," as the case may be. These products shall contain no more than 10 percent of added water and/or ice, 30 percent fat and shall comply with the other provisions for cooked sausages that are in this subchapter.

§ 319.182 Liver sausage and braunschweiger.

"Liver Sausage" and "Braunschweiger" are cooked sausages made from fresh and/or frozen pork and pork livers and/or beef livers and may contain cured pork, beef and veal, and pork fat. Liver sausage may also contain beef and pork byproducts, pork skins, sheep livers and goat livers. These products shall contain not less than 30 percent of liver computed on the weight of the fresh liver and may contain binders and extenders as permitted in § 319.140.

Subpart H-[Reserved]

Subpart I-Semi-Dry Fermented Sausage [Reserved]

Subpart J-Dry Fermented Sausage [Reserved]

Subpart K-Luncheon Meat, Loaves and Jellied Products

in his judgment, delay in terminating its eligibility could result in the importation of adulterated or misbranded product. Certifications of official establishments by the responsible official of the foreign meat inspection system shall be in the following form:

FOREIGN OFFICIAL MEAT ESTABLISHMENT CERTIFICATE

I hereby certify that the establishment(s) listed below fully comply (complies) with requirements of (specify foreign country) at least equal to all the inspection, building construction standards, and other requirements for the slaughter and preparation of the carcasses, parts thereof, meat and meat food products of cattle, sheep, swine, goats, and equines applied to official establishments in the United States under the Federal Meat Inspection Act and otherwise meet (meets) the requirements of § 327.2(a) of the regulations governing meat inspection of the U.S. Department of Agriculture.

Control numbers	Name	Address
.....
.....
.....

Date.....

Signature.....

Official Title.....

(4) Product of cattle, sheep, swine, and goats from foreign countries not listed in paragraph (b) of this section and product of equines from countries not listed in paragraph (c) of this section is not eligible for importation into the United States, except as provided by § 327.16 or § 327.17. The listing of any foreign country under this section may be withdrawn whenever it shall be determined by the Administrator that the system of meat inspection maintained by such foreign country does not assure compliance with requirements at least equal to all the inspection, building construction standards, and other requirements of the Act and the regulations in this subchapter as applied to official establishments in the United States; or that reliance cannot be placed upon certificates required under this part from authorities of such foreign country; or that, for lack of current information concerning the system of meat inspection being maintained by such foreign country, such foreign country should be required to reestablish its eligibility for listing.

(b) It has been determined that product of cattle, sheep, swine, and goats from the following countries, covered by foreign meat inspection certificates of the country of origin as required by § 327.4, except fresh, chilled, or frozen, or other product ineligible for importation into the United States from countries in which the contagious and communicable disease or rinderpest, or of foot-and-mouth disease, or of African swine fever exists as provided in Part 94 of this title, is eligible under the regulations in this subchapter for importation into the United States after inspection and marking as required by the applicable provisions of this part.

Argentina.	Ireland (Eire).	
Australia.	Italy.	
Austria.	Japan.	
Belgium.	Luxembourg.	
Belize.	Mexico.	
Brazil.	Netherlands.	
Bulgaria.	New Zealand.	
Canada.	Nicaragua.	
Colombia.	Northern Ireland.	
Costa Rica.	Norway.	
Czechoslovakia.	Panama.	
Denmark.	Paraguay.	
Dominican Republic.	Poland.	
El Salvador.	Republic of China (Taiwan).	*
England and Wales.	Romania.	
Finland.	Scotland.	
France.	Spain.	
Germany (Federal Republic).	Sweden.	
Guatemala.	Switzerland.	
Haiti.	Trust Territory of the Pacific Islands.	
Honduras.	Uruguay.	
Hungary.	Venezuela.	
Iceland.	Yugoslavia.	

(c) It has been determined that product of equines from the following countries, covered by foreign meat inspection certificates of the country of origin as required by § 327.4, is eligible under the regulations in this subchapter for importation into the United States after inspection and marking as required by the applicable provisions of this part.

Argentina.	New Zealand.
Canada.	Paraguay.
Mexico.	

§ 327.3 No product to be imported without compliance with applicable regulations.

(a) No product offered for importation from any foreign country shall be admitted into the United States if it is adulterated or misbranded or does not comply with all the requirements of this subchapter that would apply to it if it were a domestic product.

(b) No fresh or cured meat or meat trimmings in pieces too small to permit adequate inspection upon arrival shall be admitted into the United States. Individual pieces or trimmings must not be smaller than 2-inch cubes or pieces comparable in size. Except as provided in paragraph (c) of this section, processed meat food products prepared with meat pieces smaller than 2-inch cubes or pieces comparable in size shall not be permitted entry except under the following conditions:

§ 350.5 Application for service.

Any person who desires to receive service under the regulations in this part for meat or other product eligible therefor under such regulations may make application for service to the Administrator, upon an application form which will be furnished by the Administrator upon request.

§ 350.6 Denial or withdrawal of service.

(a) If any person has applied for service for meat or other product not eligible therefor under the regulations in this part, or has failed to make proper application for service or to pay fees and charges due for service furnished or to be furnished to him under the regulations in this part, or if the service cannot be furnished to any person applying therefor because of lack of available inspectors or other administrative reasons, the service may be denied to such person by the Administrator until the condition justifying such denial is corrected.

(b) Service under the regulations in this part may also be denied to any person by the Administrator for such period as he may deem proper, if it is determined, after opportunity for hearing before a proper official in the Department, that such person has been responsible for any willful misrepresentation to the Department concerning any meat or other product for which service has been requested under the regulations, in this part, or that such person has been responsible for the use without authority, or the imitation, of any marks or certificates of Federal meat inspection on or with respect to any meat or other product, or has otherwise been responsible for any fraudulent or deceptive practice with respect to such service, or that such person has interfered with or obstructed any inspector in the performance of his duties under the regulations in this part, or attempted to do so. Pending final determination of the matter, the Administrator may deny or withdraw service without hearing in those cases where the public interests so require. In other cases prior to the institution of proceedings for denial of service under this paragraph, the facts or conduct which may warrant such action shall be called to the attention of the person involved, in writing, and he shall be given an opportunity to demonstrate or achieve compliance with all applicable requirements.

§ 350.7 Fees and charges.

(a) Fees and charges for service under the regulations in this part shall be paid by the applicant for the service in accordance with this section, and, if required by the Administrator, the fees and charges shall be paid in advance.

(b) The fees and charges provided for in this section shall be paid by check, draft, or money order payable to the Treasurer of the United States and shall be remitted promptly to the Administrator upon furnishing to the applicant of a statement as to the amount due.

(c) The fees to be charged and collected for service under the
* regulations in this part shall be at the rate of \$13.20 per hour for base time, *
* \$13.20 per hour for overtime including Saturdays, Sundays, and holidays, and *
\$19.92 per hour for laboratory service, to cover the costs of the service and

*shall be charged for the time required to render such service. Where appropriate, this time will include but will not be limited to the time required for the travel of the inspector or inspectors in connection therewith during the regularly scheduled administrative workweek. *

(d) Charges may also be made to cover the cost of travel and other expenses incurred by the Service in connection with the furnishing of the service.

[23 F.R. 9982, Dec. 23, 1958, as amended at 32 F.R. 13115, Sept. 15, 1967; 35 F.R. 6856, Apr. 30, 1970]

PART 351-CERTIFICATION OF TECHNICAL ANIMAL FATS FOR EXPORT

AUTHORITY: The provisions of this Part 351 issued under secs. 203, 205, 60 Stat. 1087, 1090; 7 U.S.C. 1622, 1624.

SOURCE: The provisions of this Part 351 appear at 40 FR 58627, December 18, 1975.

DEFINITIONS

§ 351.1 Meaning of words.

Words used in this Part in the singular form shall be deemed to import the plural, and vice versa, as the case may demand.

§ 351.2 Terms defined.

When used in this Part, unless the context otherwise requires:

(a) "Department" means the United States Department of Agriculture.

(b) "Program" means the Meat and Poultry Inspection Program of the Animal and Plant Health Inspection Service of the Department.

(c) "Administrator" means the Administrator of the Animal and Plant Health Inspection Service of the Department, or any officer or employee of the Department to whom authority has heretofore been delegated or may hereafter be delegated to act in his stead.

(d) "Circuit supervisor" means an employee of the Program assigned to supervise and perform official work in a circuit. Such employee is assigned by and reports directly to the Administrator or person designated by him.

(e) "Inspector" means an employee of the Program or a cooperating State.

(f) "Circuit" means one or more inspected plants assigned to a circuit supervisor.

(g) "Recognized State" means any State not designated in § 331.2 of this chapter.

(h) "Cooperating State" means any State cooperating under § 351.7 in administration of the regulations in this Part.

(i) "Inspection" means ante-mortem and post-mortem inspection by Program inspectors or inspectors of a Meat Inspection Service of a recognized State.

(j) "Animals" means cattle, sheep, swine, goats, horses, mules and other equines.

(k) "Technical animal fat" means animal fat eligible for exportation, or storage for exportation, in accordance with § 325.11 of this chapter.

(l) "Certified technical animal fat" means technical animal fat certified

shipping technical animal fat from the plant or facility and storing and exporting such technical animal fat, and a written description of the shipping, receiving, and inventory records maintained for technical animal fat.

(d) The Administrator will determine, on the basis of all information available to him, whether the arrangements at the plant or storage facility are such as will assure that certifications of technical animal fat will be correct, and, if so, will grant the application for certification service. An applicant will be given an opportunity to present his views prior to refusal of the service.

§ 351.6 Official number.

The Administrator will assign a certified technical animal fat plant number to each plant granted service. Such number shall be preceded by the letter "C" and be used to identify all certified technical animal fat prepared or stored by the plant.

§ 351.7 Administration of certification service program.

(a) The regulations in this Part shall be administered by the circuit supervisor for the jurisdiction in which is located the certified plant or plants for which application for certification service is made, and such assistants as may be necessary will be assigned by the Administrator.

(b) The Administrator may enter into a cooperative agreement with any recognized State for the conduct by State employees of any surveys, examinations, and other activities involved in the administration of the regulations in this Part. However, certifications under these regulations may be issued only by Program employees, as provided in § 351.3.

FEES

§ 351.8 Charges for surveys of plants.

Applicants for the certification service shall pay the Department for
* salary costs at \$13.20 per hour, travel and per diem allowances at rates *
currently allowed by the Government Travel Regulations, and other expenses
incidental to the initial survey of the rendering plants or storage facilities
for which certification service is requested.

§ 351.9 Charges for examinations.

(a) The hourly fees to be charged and collected by the Administrator
* shall be \$13.20 per hour for examinations, as provided for in § 351.14, and *
\$19.92 per hour for any laboratory service required to determine the eligibili-
ty of any technical animal fat for certification under the regulations in this
Part. Such fees shall be charged for the time required to render such service,
including, but not limited to, the time required for the travel of the
inspector or inspectors in connection therewith.

(b) Charges may also be made to cover the actual cost of travel and per
diem allowance at rates currently allowed by the General Services Administra-
tion, and other expenses incurred by the Department in connection with such
examinations and laboratory service.

(b) The charges for inspection service will be based on the time required *
*to perform such services. The hourly rate shall be \$13.20 for base time and *
*\$13.20 for overtime or holiday work. *

(c) Charges for any laboratory analysis or laboratory examination of rabbits under this Part related to the inspection service shall be \$19.92 per hour.

§ 354.105 Fees for additional copies of inspection certificates.

Additional copies, other than those provided for in §§ 354.141, 354.142, and 354.143, of any inspection certificates may be supplied to any interested party upon payment of a fee of \$2.00 for each set of five or fewer copies.

§ 354.106 Travel expenses and other charges.

Charges are to be made to cover the cost of travel and other expenses incurred by the Service in connection with rendering inspection service. Such charges shall include the costs of transportation, per diem, and any other expenses.

§ 354.107 Continuous inspection performed on a resident basis.

(a) Except as provided in paragraph (b) of this section, the charges for inspection of rabbits and products thereof shall be those provided for in § 354.101(b) when the inspection service is performed on a continuous year-round resident basis and the services of an inspector or inspectors are required 4 or more hours per day. When the services of an inspector are required on an intermittent basis, the charges shall be at the hourly rate provided for in § 354.101(b) plus the travel expense and other charges provided for in § 354.106.

(b) The applicant will be given credit when inspectors assigned to the applicant's official plant perform inspection for the Department of Defense on products accepted for delivery by the applicant to the Department of Defense. The amount of such credit will be based on a formula concurred in jointly by the Departments of Defense and Agriculture.

§ 354.109 Fees or charges for inspection service performed under cooperative agreement.

Fees or charges to be made to an applicant for any inspection service which differ from those listed in §§ 354.100 through 354.107 shall be provided for by a cooperative agreement.

§ 354.110 Disposition of fees for inspection made under cooperative agreement.

Fees for inspection under a cooperative agreement with any State or person shall be disposed of in accordance with the terms of such agreement. Such portion of the fees collected under a cooperative agreement as may be due the United States shall be remitted to the Service.

INSPECTION PROCEDURES; ANTE-MORTEM INSPECTIONS

§ 354.120 Manner of handling products in an official plant.

reimburse the Department for salary, travel cost, per diem allowance, and the like, expended incidental to any survey of the premises for which the inspection is requested, and in connection with any review of plans which may be made.

§ 355.12 Charge for service.

- * The fees to be charged and collected by the Administrator shall be \$13.20 *
- * per hour for base time, \$13.20 per hour for overtime including Saturdays, *
- Sundays, and holidays, and \$19.92 per hour for laboratory service to reimburse
- the Service for the cost of the inspection services so furnished.

SANITATION AND FACILITIES

§ 355.13 Sanitation.

Sanitary facilities and accommodations shall be furnished by every inspected plant. Of these the following are specifically required:

(a) Dressing rooms, toilet rooms, and urinals shall be sufficient in number, ample in size, and conveniently located. They shall be properly lighted and ventilated and of sanitary construction. They shall be separate from the rooms and compartments in which certified products are prepared, stored or handled.

(b) Modern hand-washing basins, including running hot and cold water, soap and towels shall be placed in or near toilet rooms.

(c) Toilet soil lines shall be separate from house drainage lines to a point outside the buildings and drainage from toilet soil lines shall not be discharged into a grease catchbasin.

(d) Properly located facilities shall be provided for cleansing utensils and hands of all persons handling or preparing any products to be certified.

(e) Equipment and utensils used for preparing any products to be certified shall be of such material and construction as will make them susceptible of being readily and thoroughly cleaned.

(f) Trucks and receptacles used for inedible materials shall be of such construction as to permit ready and thorough cleansing, shall bear a conspicuous and distinctive mark, and shall be used exclusively for handling inedible material.

(g) Rooms, compartments, places, equipment and utensils used for preparing, storing or otherwise handling any certified products, and all other parts of the inspected plant, shall be kept clean. There shall be no handling or storing of materials which creates an objectionable condition in rooms, compartments or places where certified products are prepared, stored or otherwise handled.

§ 355.14 Facilities.

Adequate facilities for the preparation and inspection of the products to be certified shall be furnished and maintained by the inspected plant. Of these the following are specifically required:

(a) A room or compartment adequately equipped for locking or sealing shall be provided for holding products prepared for certification or material used in their preparation which are identified as "U.S. retained," and such rooms and compartments shall be conspicuously marked with the phrase "U.S. retained" prominently displayed.

(b) Adequate facilities, including denaturing materials, for the proper disposal of condemned articles including carcasses, parts of carcasses and other materials, shall be provided.

(c) Rooms or compartments adequate in size and properly equipped for holding samples of canned products prepared for certification under incubation, shall be maintained at the temperature specified in § 355.25(i).

(d) Furnished office room, including light, heat, janitor, and laundry service shall be provided rent free for the exclusive use of the inspector. These facilities shall be set apart for this purpose and provided with lockers suitable for the protection and storage of program supplies. Laundering of inspectors' outer work clothing shall be provided by the management of inspected plants.

§ 355.15 Inedible material operating and storage rooms; outer premises, docks, driveways, etc.; fly-breeding material; nuisances.

All operating and storage rooms and departments of inspected plants used for inedible material shall be maintained in clean condition, and shall be separate and apart from rooms and departments where certified products are prepared, handled, or stored. Docks and areas where cars and vehicles are loaded, and driveways, approaches and alleyways shall be properly paved and drained and the outer premises of every inspected plant shall be kept in clean and orderly condition. All catchbasins on the premises shall be of such construction and location and shall be given such attention as will insure their being kept in acceptable condition as regards odors and cleanliness. The accumulation on the premises of any material in which flies may breed, or the maintenance of any nuisance on the premises shall not be allowed.

§ 355.16 Control of flies, rats, mice, etc.

Flies, rats, mice, and other vermin shall be excluded from inspected plants and premises.

§ 355.17 Tagging equipment "U.S. rejected."

When necessary, inspectors shall attach a "U.S. rejected" tag to any equipment or utensil which is unclean or the use of which would be in conflict with the provisions of this part. No equipment or utensil so tagged shall again be used until made acceptable under this part and until removal of the tag. Such tag shall not be removed from the equipment or utensil by anyone other than an inspector.

§ 355.18 Drawings and specifications to be furnished.

Triplicate copies of complete drawings and specifications for remodeling

§ 362.5 Fees and charges.

(a) Fees and charges for service under the regulations in this Part shall be paid by the applicant for the service in accordance with this section, and, if required by the Administrator, the fees and charges shall be paid in advance.

(b) The fees and charges provided for in this section shall be paid by check, draft, or money order payable to the Treasurer of the United States and shall be remitted promptly to the Administrator upon furnishing to the applicant a statement as to the amount due.

(c) The fees to be charged and collected for service under the regulations in this Part shall be at the rate of \$13.20 per hour for base time, *
* \$13.20 per hour for overtime including Saturdays, Sundays, and holidays, and *
\$19.92 per hour for laboratory service to cover the costs of the service and shall be charged for the time required to render such service, including but not limited to the time required for the travel of the inspector or inspectors in connection therewith during the regularly scheduled administrative work-week.

(d) Charges may also be made to cover the cost of travel and other expenses incurred by the Service in connection with the furnishing of the service.

THE REVERSE OF THIS PAGE IS INTENDED TO BE BLANK.

decision was correct. Review of such appeal determination, when requested, shall be made by the immediate superior of the employee of the Department making the appeal determination. The cost of any such appeal shall be borne by the appellant if the Administrator determines that the appeal is frivolous. The charges for such frivolous appeal shall be at the rate of \$9.28 per hour for the time required to make the appeal inspection. The poultry or poultry products involved in any appeal shall be identified by U.S. retained tags and segregated in a manner approved by the inspector pending completion of an appeal inspection.

Subpart G-Facilities for Inspection; Overtime and Holiday Service;
Billing Establishments

§ 381.36 Facilities required.'

(a) Inspector's Office. Office space, including, but not being limited to furnishings, light, heat, and janitor service, shall be provided rent free in the official establishment, for the use of Government personnel for official purposes. The room or space set apart for this purpose must meet the approval of the Inspection Service and be conveniently located, properly ventilated, and provided with lockers or file cabinets suitable for the protection and storage of supplies and with facilities suitable for inspectors to change clothing. At the discretion of the Administrator, small plants requiring the services of less than one full-time inspector need not furnish facilities for Program employees as prescribed in this section, where adequate facilities exist in a nearby convenient location. Each official establishment shall provide commercial laundry service for inspectors' outer work clothing, or disposable outer work garments designed for one-time use, or uniform rental service garments which are laundered by the rental service.

(b) Facilities for ante-mortem inspection. Batteries, coops, or other facilities in which live poultry is presented for ante-mortem inspection shall be of such arrangement and construction, and shall be so placed with sufficient light provided so that the inspector can clearly see the birds to the extent needed to carry out an adequate inspection.

§ 381.37 Schedule of operations.

(a) No operations requiring inspection shall be conducted except under the supervision of an Inspection Service employee. All eviscerating of poultry and further processing shall be done with reasonable speed, considering the official establishment's facilities.

(b) A shift is a regularly scheduled operating period, exclusive of mealtime. One lunch period is the only official authorized interruption in the inspector's tour of duty once it begins. Lunch periods may be 30 minutes, 45 minutes, or in any case may not exceed one hour in duration. Once established, the lunch period must remain relatively constant as to time and duration. Lunch periods for inspectors shall not, except as provided herein, occur prior to 4 hours after the beginning of scheduled operations nor later than 5 hours after operations begin. In plants where a company rest break of not less than 30 minutes is regularly observed, approximately midpoint between start of work and the lunch period, and the inspector is allowed this time to meet his personal needs, the lunch period may be scheduled as long as 5 1/2 hours after the beginning of scheduled operations.

(c) Official establishments, importers, and exporters shall be provided inspection service, without charge, up to 8 consecutive hours per shift during the basic workweek subject to the provisions of § 381.38: Provided, That any additional shifts meet requirements as determined by the Administrator or his designee. The basic workweek shall consist of five consecutive 8-hour days Monday through Friday, excluding the lunch period; except those plants presently operating on an approved Tuesday through Saturday schedule shall continue on this schedule until such time as a change in ownership occurs, or they request and are granted a Monday through Friday work schedule; and further, except in the designation of State programs, the Department may depart from the Monday to Friday workweek in those cases where it would seriously handicap the Department in carrying out its function.

(d) (1) Each official establishment shall submit a work schedule to the area supervisor for approval. In consideration of whether the approval of an establishment work schedule shall be given, the area supervisor shall take in account the efficient and effective use of inspection personnel. The work schedule must specify the workweek, daily clock hours of operation, and lunch periods for all departments of the establishment requiring inspection.

(2) Establishments shall maintain consistent work schedules. Any request by an establishment for a change in its work schedule involving changes in the workweek or an addition or elimination of shifts shall be submitted to the area supervisor at least 2 weeks in advance of the proposed change. Frequent requests for change shall not be approved: Provided, however, minor deviations from a daily operating schedule may be approved by the inspector in charge if such request is received on the day preceding the day of change.

(3) Requests for inspection service outside an approved work schedule shall be made as early in the day as possible for overtime work to be performed within that same workday; or made prior to the end of the day's operation when such a request will result in overtime service at the start of the following day: Provided, That an inspector may be recalled to his assignment after the completion of his daily tour of duty under the provisions of § 381.39(b).

§ 381.38 Overtime and holiday inspection service.

(a) The management of an official establishment, an importer, or an * exporter shall pay the Animal and Plant Health Inspection Service \$13.20 per * hour per Program employee to reimburse the Program for the cost of the inspection service furnished on any holiday specified in paragraph (b) of this section; or for more than 8 hours on any day, or more than 40 hours in any administrative workweek Sunday through Saturday.

(b) Holidays for Federal employees shall be New Year's Day, January 1; Washington's Birthday, the third Monday in February; Memorial day, the last Monday in May; Independence day, July 4; Labor Day, the first Monday in September; Columbus Day, the second Monday in October; Veterans' Day, the fourth Monday in October; Thanksgiving Day, the fourth Thursday in November; Christmas Day, December 25. When any of the above-listed holidays falls outside the basic workweek, the nearest workday within that week shall be the holiday.

UNITED STATES DEPARTMENT OF AGRICULTURE
Animal and Plant Health Inspection Service
Washington, D.C. 20250

Official Business
Penalty for Private Use, \$300

POSTAGE AND FEES PAID
U.S. DEPARTMENT OF
AGRICULTURE
AGR 101

